

Date: Tuesday, 12/20/2005 9:48:20 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 206L UTILITY BASKET
<b>Job Number</b> : 23136	
<b>Estimate Number</b> : 11272	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D206540011
<b>This Issue</b> : 12/20/2005 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : UNDER REVIEW
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : 1
<b>Previous Run</b> : N/A	<b>Material</b> : N/A
<b>Written By</b> : SEE COMMENT BELOW	<b>Due Date</b> : 1/30/2006
<b>Checked &amp; Approved By</b> : SEE COMMENT BELOW	<b>Qty:</b> 1 <b>Um:</b> Each
<b>Comment</b> : Est Rev:1 Revised per Rev 1 05-12-06 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPPD206-540-011 CHG004

DA 06-01-23

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick: Assembly Kit

3.0	23136A	206L BASKET BASE
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**Comment:** Sub-Component 206L BASKET BASE

4.0	23136B	206L BASKET LID
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**Comment:** Sub-Component 206L BASKET LID

5.0	D2332041	Lid Prop Assembly 6.69"
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2332-041 Prop Ass'y B24531

6.0	D2022101	Spacer
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2022-101 SPACER B23396

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: 206L UTILITY BASKET

Job Number: 23136

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0 ✓

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment B24876

8.0 ✓

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring B24532

9.0 ✓

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537 Bushing B24877

10.0

D2931

Bumper



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 D2931 Bumper B21139

11.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS20600AD4W3 Rivet M13767

12.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN4-7A Bolt M17697

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 206L UTILITY BASKET

Job Number: 23136

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-24A

Bolt M17204

14.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-16A

Bolt M17073

15.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-22A

Bolt M18 822

16.0

AN517A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

6 AN5-17A

Bolt M16273

17.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN960JD416

Washer M18431

18.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN960JD516

Washer M18100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 206L UTILITY BASKET

Job Number: 23136

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer M16895

20.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD8 Washer M11729

21.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M18180

22.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4) M17997

23.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L5 Nut (or -5) M17694

SAD 06:01:21

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 206L UTILITY BASKET

Job Number: 23136

Part Number: D206540011

Job Number:



Seq. #: Machine Or Operation: Description :

24.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D206-540

SAD

06:01:22

1

25.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06:01:23

P10

26.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

27.0 D2249041 Fitting Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 d2249-041 bracket

B22498

28.0 D2252041 - Basket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

1 D2252-041 bracket

B225298

29.0 D2258170 Placard - 170 lb



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit D2258-170

1 D2258-170 PLACARD

B16266

30.0 D2259 Label





Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

1 D2259 Placard

B10671

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-01-23	10	2 bumpers on front side of basket : 2 bumpers on back side of lid installed. bumpers on lid to be replaced by shims (plastic) installed on back side of basket base. (under review)					

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/01/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 206L UTILITY BASKET

Job Number: 23136

Part Number: D206540011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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31.0	D2525	Spacer Kit
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2525 Spacer kit

B12105

32.0	D2526	Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2526 Bushing

B17519

33.0	D2537	Bushing
------	-------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2537 BUSHING

B24877

34.0	D2748	Clevis
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2748 Clevis

B15196

35.0	D27495	Strut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2749-5 Strut

B15232

36.0	D27497	Strut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2749-7 Strut

B10983

37.0	AN421A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN4-21A Bolt

*[Handwritten signature]*  
*Re: 0123*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 23136

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

AN45A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

8 AN4-5A Bolt

*M18499*

39.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN4-12A Bolt

*M17771*

40.0

AN421A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN4-21A Bolt

*M2951*

41.0

AN517A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN5-17A Bolt

*M16273*

42.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416 Washer

*M18431*

43.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN960JD516 Washer

*M18254*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 206L UTILITY BASKET

Job Number: 23136

Part Number: D206540011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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44.0	MS21042L4	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4) M17997

45.0	MS21042L5	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 MS21042L5 Nut

M17694

4/1/23

(1)

46.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

C206/01/23

47.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-540-011

Location:

PPP Rev: 6

4/1/23

(1)

48.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/23

(1)

06/01/23

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23136
<b>Description:</b> 206L/L1/L3/L4 Utility Basket Instl'n	<b>Part Number:</b>	D206-540-011
<b>Drawing:</b> D206-540 Rev. H Pages 1,7 & 8	<b>Qty:</b>	1
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty																																																																																																																																																								
1	DC	Issue Travellers for: D206-540-011 Utility Basket Instl'n D2252-041 Base D2252-043 Lid	Batch 23136 23136 23136	05.01.29	1																																																																																																																																																								
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3	WS	Go to Traveller D2252-041; D2252-043																																																																																																																																																											
4	PK	<p><b>Pick: Ass'y Kit</b></p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D2258-170</td><td>Placard</td><td></td></tr><tr><td>1</td><td>D2332-041</td><td>Prop Ass'y</td><td>B24531</td></tr><tr><td>1</td><td>D2530</td><td>Handle weldment</td><td></td></tr><tr><td>2</td><td>D2537</td><td>Bushing</td><td>B24877</td></tr><tr><td>1</td><td>D2569</td><td>Hinge</td><td></td></tr><tr><td>2</td><td>D2535</td><td>Spring</td><td>B24532</td></tr><tr><td>2</td><td>D2931</td><td>Bumper</td><td>B21139</td></tr><tr><td>38</td><td>AD64ABS</td><td>Rivet</td><td></td></tr><tr><td>2</td><td>MS20600AD4W3</td><td>Rivet</td><td>M13767</td></tr><tr><td>2</td><td>AN3-16A</td><td>Bolt</td><td>M17073</td></tr><tr><td>2</td><td>AN4-22A</td><td>Bolt</td><td>M18824</td></tr><tr><td>4</td><td>AN5-17A</td><td>Bolt</td><td>M16273</td></tr><tr><td>2</td><td>AN960JD416 L</td><td>Washer</td><td>M19477</td></tr><tr><td>4</td><td>AN960JD516</td><td>Washer</td><td>M18100</td></tr><tr><td>2</td><td>AN960JD8</td><td>Washer</td><td>M11729</td></tr><tr><td>4</td><td>AN970-4</td><td>Washer</td><td>M16895</td></tr><tr><td>2</td><td>MS21042L3</td><td>Nut</td><td>M18180</td></tr><tr><td>2</td><td>MS21042L4</td><td>Nut</td><td>M17992</td></tr><tr><td>4</td><td>MS21042L5</td><td>Nut</td><td>M17694</td></tr><tr><td>1</td><td>D2851-170</td><td>Placard</td><td>B21514</td></tr></tbody></table> <p><b>Pick: Packing Kit</b></p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>2</td><td>D2249-041</td><td>Bracket</td><td></td></tr><tr><td>1</td><td>D2259</td><td>Placard</td><td></td></tr><tr><td>2</td><td>D2525</td><td>Spacer kit</td><td></td></tr><tr><td>2</td><td>D2526</td><td>Bushing</td><td></td></tr><tr><td>2</td><td>D2748</td><td>Clevis</td><td></td></tr><tr><td>1</td><td>D2749-5</td><td>Strut</td><td></td></tr><tr><td>1</td><td>D2749-7</td><td>Strut</td><td></td></tr><tr><td>2</td><td>AN4-12A</td><td>Bolt</td><td></td></tr><tr><td>8</td><td>AN4-5A</td><td>Bolt</td><td></td></tr><tr><td>2</td><td>AN5-17A</td><td>Bolt</td><td></td></tr><tr><td>2</td><td>AN4-21A</td><td>Bolt</td><td></td></tr><tr><td>12</td><td>AN960JD416</td><td>Washer</td><td></td></tr><tr><td>2</td><td>AN960JD516</td><td>Washer</td><td></td></tr><tr><td>4</td><td>MS21042L4</td><td>Nut</td><td></td></tr><tr><td>2</td><td>MS21042L5</td><td>Nut</td><td></td></tr><tr><td>2</td><td>D2852</td><td>Placard</td><td></td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D2258-170	Placard		1	D2332-041	Prop Ass'y	B24531	1	D2530	Handle weldment		2	D2537	Bushing	B24877	1	D2569	Hinge		2	D2535	Spring	B24532	2	D2931	Bumper	B21139	38	AD64ABS	Rivet		2	MS20600AD4W3	Rivet	M13767	2	AN3-16A	Bolt	M17073	2	AN4-22A	Bolt	M18824	4	AN5-17A	Bolt	M16273	2	AN960JD416 L	Washer	M19477	4	AN960JD516	Washer	M18100	2	AN960JD8	Washer	M11729	4	AN970-4	Washer	M16895	2	MS21042L3	Nut	M18180	2	MS21042L4	Nut	M17992	4	MS21042L5	Nut	M17694	1	D2851-170	Placard	B21514	Qty	Part Number	Description	Batch	2	D2249-041	Bracket		1	D2259	Placard		2	D2525	Spacer kit		2	D2526	Bushing		2	D2748	Clevis		1	D2749-5	Strut		1	D2749-7	Strut		2	AN4-12A	Bolt		8	AN4-5A	Bolt		2	AN5-17A	Bolt		2	AN4-21A	Bolt		12	AN960JD416	Washer		2	AN960JD516	Washer		4	MS21042L4	Nut		2	MS21042L5	Nut		2	D2852	Placard				
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1	D2569	Hinge																																																																																																																																																											
2	D2535	Spring	B24532																																																																																																																																																										
2	D2931	Bumper	B21139																																																																																																																																																										
38	AD64ABS	Rivet																																																																																																																																																											
2	MS20600AD4W3	Rivet	M13767																																																																																																																																																										
2	AN3-16A	Bolt	M17073																																																																																																																																																										
2	AN4-22A	Bolt	M18824																																																																																																																																																										
4	AN5-17A	Bolt	M16273																																																																																																																																																										
2	AN960JD416 L	Washer	M19477																																																																																																																																																										
4	AN960JD516	Washer	M18100																																																																																																																																																										
2	AN960JD8	Washer	M11729																																																																																																																																																										
4	AN970-4	Washer	M16895																																																																																																																																																										
2	MS21042L3	Nut	M18180																																																																																																																																																										
2	MS21042L4	Nut	M17992																																																																																																																																																										
4	MS21042L5	Nut	M17694																																																																																																																																																										
1	D2851-170	Placard	B21514																																																																																																																																																										
Qty	Part Number	Description	Batch																																																																																																																																																										
2	D2249-041	Bracket																																																																																																																																																											
1	D2259	Placard																																																																																																																																																											
2	D2525	Spacer kit																																																																																																																																																											
2	D2526	Bushing																																																																																																																																																											
2	D2748	Clevis																																																																																																																																																											
1	D2749-5	Strut																																																																																																																																																											
1	D2749-7	Strut																																																																																																																																																											
2	AN4-12A	Bolt																																																																																																																																																											
8	AN4-5A	Bolt																																																																																																																																																											
2	AN5-17A	Bolt																																																																																																																																																											
2	AN4-21A	Bolt																																																																																																																																																											
12	AN960JD416	Washer																																																																																																																																																											
2	AN960JD516	Washer																																																																																																																																																											
4	MS21042L4	Nut																																																																																																																																																											
2	MS21042L5	Nut																																																																																																																																																											
2	D2852	Placard																																																																																																																																																											

RELEASED  
02/08/03 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23136
<b>Description:</b> 206L/L1/L3/L5 Utility Basket Inst'n	<b>Part Number:</b>	D206-540-011
<b>Drawing:</b> D206-540 Rev. H Pages 1,7 & 8	<b>Qty:</b>	1
		Page 2 of 2

Step	Location	Procedure	By	Date	Qty												
5	GA	Assemble as per Dwg D206-540 Attach Travellers: <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>1</td><td>D2252-041</td><td>Base</td><td>23136 B A</td></tr><tr><td>1</td><td>D2252-043</td><td>Lid</td><td>23136 A B</td></tr></table>	Qty	Part Number	Description	Batch	1	D2252-041	Base	23136 B A	1	D2252-043	Lid	23136 A B	JAD	06/01/22	1
Qty	Part Number	Description	Batch														
1	D2252-041	Base	23136 B A														
1	D2252-043	Lid	23136 A B														
6	QC5	Inspect for foreign object per QSI 024 & Assembly work to Step 5															
7	QC4	Inspect 100% kit for completeness															
8	PK	Box and identify as per PPP D206-540-011															
9	AC	Cost / part:															
10	DC	Close Work Order and Ensure Travellers Attached Inspect Level 21 Travellers: D206-540-011 D2252-041 D2252-043															

Rev	Date	Change	Revised By	Approved
A				JB
B	99.10.07	Re-format	EC	
C	99.12.01	Changed V1700 bumper for D2931 (CAR 105)	EC	
D	00.04.12	Revised dwg revision	EC	
E	00.07.21	Added inspection for QSI 024	EC	
F	00.09.12	Reduced qty for bumper (TSR 1303)	EC	
G	02.07.24	Re-format Location; Modify Step 1,5	RF RF	

**RELEASED**  
02/08/08 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Apr 29, 2005  
11:31 am

Work Order No : 0023136  
Project Name : D206-540-011  
Project For : WK522  
Work Order Type : Main  
Main WO Number :  
House Part Number : \*D206-540-011  
Description : Heli-Utility-Basket (L)  
Manufactured : Yes  
Amount Req'd : 1  
Amount Done : 0  
Start Date : 04-29-05  
Est Finish Date : 05-30-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
  
Order Entry No :  
OE Value : 0.00  
  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

5/22

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23136
<b>Description:</b> 206L Basket Base	<b>Part Number:</b>	D2252-041
D2		
<b>Drawing:</b> D2252 Rev. D1 Pages 1, 3, 4 & 5; D2235 Rev. B1	<b>Qty:</b>	1

RF 04.01.23

Step	Location	Procedure	By	Date	Qty																								
1	DC	Open Traveller <b>Dwg not required</b>	9/8	05.04.29	1																								
2	WS	Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: _____ Cut Qty. 5 D2235-1 from: _____ Qty. 5 D3166-1 Batch: _____																											
3	WS	Drill hole in D2252-1 as per Dwg D2252																											
4	WS	Deburr																											
5	WS	Pick: <table><tr><td><u>Qty</u></td><td><u>Part Number</u></td><td><u>Description</u></td><td><u>Batch</u></td></tr><tr><td>2</td><td>D2253-1</td><td>Lug</td><td>_____</td></tr><tr><td>1</td><td>D2327-3</td><td>Bushing</td><td>_____</td></tr><tr><td>4</td><td>D2581</td><td>Mounting Chanel</td><td>_____</td></tr><tr><td>2</td><td>D2254</td><td>Gusset</td><td>_____</td></tr><tr><td>32 sf</td><td>M304EX0.75-16F</td><td>Expanded Metal</td><td>_____</td></tr></table>	<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>	2	D2253-1	Lug	_____	1	D2327-3	Bushing	_____	4	D2581	Mounting Chanel	_____	2	D2254	Gusset	_____	32 sf	M304EX0.75-16F	Expanded Metal	_____			
<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>																										
2	D2253-1	Lug	_____																										
1	D2327-3	Bushing	_____																										
4	D2581	Mounting Chanel	_____																										
2	D2254	Gusset	_____																										
32 sf	M304EX0.75-16F	Expanded Metal	_____																										
6	WS	Weld as per Dwg D2252 using Welding Table and corner Jig Deburr as required																											
7	QC9 & 6	Inspect Welding and Dimensions																											
8	WS	Take Traveller D206-540-011 to KP																											
9	FP	Powder Coat White (Ref. 4.3.5.2) as per QSI 005 4.3																											
10	QC3	Inspect Powder Coat																											
11	FP	To GA Cell for Assembly																											

Rev	Date	Change	Revised By	Approved
B	96.10.25			JB
C	99.09.22	Re-format, Preliminary Issue	EC	
D	99.11.01	Changed pick list, now released	EC	
E	00.02.03	Added D2235-1 to pick list, re-format	EC	
F	00.11.01	Removed P/O for Powder Coat - in house process	EC	
G	02.07.23	Re-format added D3166-1; removed inspect Level 5	KJ	
H	02.09.04	M304EX0.75-16F was M750-16FXS-S/S	KJ RF	

RELEASED  
02/09/07 RF

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

5/22

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23136
<b>Description:</b> 206L Basket Lid	<b>Part Number:</b>	D2252-043
D2		
<b>Drawing:</b> D2252 Rev. D1 Pages 1, 2 & 4	<b>Qty:</b>	1

Step	Location	Procedure	By	Date	Qty																				
1	DC	Open Traveller <b>Dwg not required</b>	RF	05.04.29	1																				
2	WS	Cut 3/4" x 3/4" square tubing as per Dwg D2252 Material: 304/316 SS tube .060" wall Batch																							
3	WS	Drill hole in D2252-1 as per Dwg D2252																							
4	WS	Deburr																							
5	WS	Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2329</td><td>Label plate</td><td></td></tr><tr><td>1</td><td>D2327-3</td><td>Bushing</td><td></td></tr><tr><td>2</td><td>D2581</td><td>Mounting Chanel</td><td></td></tr><tr><td>18 sf</td><td>M304EX0.75-16F</td><td>Expanded Metal</td><td></td></tr></table>	Qty	Part Number	Description	Batch	1	D2329	Label plate		1	D2327-3	Bushing		2	D2581	Mounting Chanel		18 sf	M304EX0.75-16F	Expanded Metal				
Qty	Part Number	Description	Batch																						
1	D2329	Label plate																							
1	D2327-3	Bushing																							
2	D2581	Mounting Chanel																							
18 sf	M304EX0.75-16F	Expanded Metal																							
6	WS	Weld as per Dwg D2252 using Welding Table and corner Jig Deburr as required																							
7	QC9 & 6	Inspect Welding and Dimensions																							
8	WS	Give Traveller D206-540-011 to Store for Kit Piking																							
9	FP	Powder Coat White (Ref. 4.3.5.2) as per QSI 005 4.3																							
10	QC3	Inspect Powder Coat																							
11	FP	To GA Cell for Assembly																							

Rev	Date	Change	Revised By	Approved
A	96.11.25			JB
B	99.09.20	Re-format, Preliminary Issue	EC	
C	99.11.02	Fixed typo, Now released	EC	
D	00.11.01	Removed P/O for Powder Coat - in house process	EC	
E	02.07.23	Re-format, removed inspect level 5, added level 6	KJ	
F	02.09.04	M304EX0.75-16F was M750-16FXS-S/S	KJ RF	RF

RELEASED  
02/09/09 RF



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_